

Date: Wednesday, 1/25/2006 1:22:04 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|--|----------------|------------------|--|-----|------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SADDLE FITTING, AFT (OUTBOARD/INBOARD) | | |
| Job Number | : 25619 | | Part Number | : D2573 | | |
| Estimate Number | : 10533 | | Drawing Number | : D2573 REV D/E <i>See Folio d.1X</i> | | |
| P.O. Number | : N/A | | Project Number | : N/A | | |
| This Issue | : 1/25/2006 | S.O. No. : N/A | Drawing Revision | : D/E | | |
| Prsht Rev. | : NC | | Material | : N/A | | |
| First Issue | : N/A | | Due Date | : 2/10/2006 | | |
| Previous Run | : 25018 | | Qty: | 12 | Um: | Each |
| Written By | : <u>See comment below</u> | | | | | |
| Checked & Approved By | : <u>SP 06.01.27</u> | | | | | |
| Comment | : Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|------------------------------------|
| 1.0 | D6101007 | 7075-T7351 8.25X7.75X2.5 |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B 24070</u> <i>5.G. 06/03/02 12</i> | | |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>25619</u> Double check by: <u>3G</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. <i>6/6/03/04 5.G. 06/03/03 12</i> | | |
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
| Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <i>EP 06/03/03 12</i> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/15
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:22:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25619

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ED 06/03/09 12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/03/09 12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:03:12 12

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML 06/03/14 (12)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06/03/14 (12)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

CL06/03/15 (12)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(12) 06/03/15

Job Completion



CL 06/03/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | | | |
|-----------------------------------|--|--|--|--------------|-------|
| DART AEROSPACE LTD | | | | Work Order: | 25L19 |
| Description: Saddle, Aft Outboard | | | | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | 0.438 | 0.438 | 0.438 | 0.438 | | |
| B | 1.745 | 1.755 | | 1.747 | 1.745 | 1.745 | 1.747 | | |
| C | 3.495 | 3.505 | | 3.497 | 3.498 | 3.499 | 3.498 | | |
| D | 1.745 | 1.755 | | 1.747 | 1.745 | 1.745 | 1.747 | | |
| E | 7.990 | 8.010 | | 8.006 | 8.004 | 8.006 | 8.004 | | |
| F | 0.490 | 0.510 | | 0.561 | 0.496 | 0.499 | 0.502 | | |
| G | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | 0.257 | 0.257 | | |
| H | 0.375 | 0.380 | DT8684 | 0.375 | 0.375 | 0.375 | 0.375 | | |
| I | 0.490 | 0.510 | | 0.502 | 0.504 | 0.504 | 0.501 | | |
| J | 1.174 | 1.184 | | 1.177 | 1.177 | 1.177 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.566 | 0.567 | 0.568 | 0.565 | | |
| L | 1.174 | 1.184 | | 1.177 | 1.177 | 1.177 | 1.177 | | |
| M | 1.365 | 1.375 | | 1.369 | 1.368 | 1.368 | 1.367 | | |
| N | 2.495 | 2.505 | | 2.495 | 2.497 | 2.498 | 2.497 | | |
| O | 4.119 | 4.129 | | 4.121 | 4.122 | 4.122 | 4.120 | | |
| P | 0.115 | 0.135 | | 0.123 | 0.123 | 0.123 | 0.122 | | |
| Q | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| R | 0.240 | 0.260 | | 0.247 | 0.248 | 0.248 | 0.248 | | |
| S | 0.115 | 0.135 | | 0.128 | 0.122 | 0.125 | 0.124 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.237 | 0.237 | 0.237 | 0.236 | | |
| W | 0.115 | 0.135 | | 0.132 | 0.131 | 0.130 | 0.131 | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.760 | 0.760 | 0.760 | 0.760 | | |
| Z | 0.352 | 0.372 | | 0.360 | 0.360 | 0.360 | 0.360 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.629 | 0.628 | 0.629 | 0.630 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.248 | 0.244 | 0.244 | 0.244 | | |
| AE | 1.500 | 1.520 | | 1.514 | 1.514 | 1.514 | 1.513 | | |
| AF | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.136 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.244 | 0.248 | 0.247 | 0.246 | | |
| AI | 2.000 | 2.020 | | 2.004 | 2.003 | 2.003 | 2.002 | | |
| AJ | 0.023 | 0.043 | | 0.030 | 0.030 | 0.030 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | EP | Audited by: | M8 |
| Date: | 06/03/06 | Date: | 06/03/06 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

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|-----------------------------------|--|--|--------------|-------|
| DART AEROSPACE LTD | | | Work Order: | 25618 |
| Description: Saddle, Aft Outboard | | | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| | | | Recorded Actual Dimensions | | | | | | |
|---------------|-------|-------|----------------------------|-------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | 0.438 | 0.438 | 0.438 | 0.438 | | |
| B | 1.745 | 1.755 | | 1.747 | 1.747 | 1.746 | 1.747 | | |
| C | 3.495 | 3.505 | | 3.497 | 3.497 | 3.498 | 3.498 | | |
| D | 1.745 | 1.755 | | 1.747 | 1.747 | 1.746 | 1.747 | | |
| E | 7.990 | 8.010 | | 8.004 | 8.006 | 8.005 | 8.005 | | |
| F | 0.490 | 0.510 | | 0.500 | 0.498 | 0.503 | 0.503 | | |
| G | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | 0.257 | 0.257 | | |
| H | 0.375 | 0.380 | DT8684 | 0.375 | 0.375 | 0.375 | 0.375 | | |
| I | 0.490 | 0.510 | | 0.500 | 0.501 | 0.499 | 0.499 | | |
| J | 1.174 | 1.184 | | 1.177 | 1.177 | 1.178 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.563 | 0.565 | 0.565 | 0.566 | | |
| L | 1.174 | 1.184 | | 1.177 | 1.177 | 1.178 | 1.178 | | |
| M | 1.365 | 1.375 | | 1.362 | 1.368 | 1.368 | 1.368 | | |
| N | 2.495 | 2.505 | | 2.497 | 2.498 | 2.498 | 2.498 | | |
| O | 4.119 | 4.129 | | 4.121 | 4.123 | 4.122 | 4.122 | | |
| P | 0.115 | 0.135 | | 0.123 | 0.125 | 0.122 | 0.123 | | |
| Q | 0.115 | 0.135 | | 0.120 | 0.130 | 0.130 | 0.130 | | |
| R | 0.240 | 0.260 | | 0.248 | 0.250 | 0.248 | 0.249 | | |
| S | 0.115 | 0.135 | | 0.128 | 0.127 | 0.126 | 0.125 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.232 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.240 | 0.236 | 0.236 | 0.236 | | |
| W | 0.115 | 0.135 | | 0.132 | 0.131 | 0.131 | 0.131 | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.760 | 0.760 | 0.760 | 0.760 | | |
| Z | 0.352 | 0.372 | | 0.360 | 0.360 | 0.360 | 0.360 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.627 | 0.630 | 0.630 | 0.629 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.249 | 0.243 | 0.249 | 0.248 | | |
| AE | 1.500 | 1.520 | | 1.514 | 1.516 | 1.513 | 1.514 | | |
| AF | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.243 | 0.246 | 0.245 | 0.245 | | |
| AI | 2.000 | 2.020 | | 2.003 | 2.005 | 2.003 | 2.004 | | |
| AJ | 0.023 | 0.043 | | 0.030 | 0.030 | 0.030 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | By J.G. | Audited by: | J.G. |
| Date: | 06/03/07 | Date: | 06/03/07 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | | | | |
|-----------------------------------|--|--|--|--------------|-------|
| DART AEROSPACE LTD | | | | Work Order: | 25619 |
| Description: Saddle, Aft Outboard | | | | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | 0.438 | 0.438 | 0.438 | 0.438 | | |
| B | 1.745 | 1.755 | | 1.747 | 1.747 | 1.746 | 1.746 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.501 | 3.498 | 3.499 | | |
| D | 1.745 | 1.755 | | 1.747 | 1.747 | 1.746 | 1.746 | | |
| E | 7.990 | 8.010 | | 8.003 | 8.004 | 8.006 | 8.004 | | |
| F | 0.490 | 0.510 | | 0.499 | 0.500 | 0.502 | 0.500 | | |
| G | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | 0.257 | 0.257 | | |
| H | 0.375 | 0.380 | DT8684 | 0.375 | 0.375 | 0.375 | 0.375 | | |
| I | 0.490 | 0.510 | | 0.501 | 0.500 | 0.503 | 0.498 | | |
| J | 1.174 | 1.184 | | 1.177 | 1.177 | 1.177 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.568 | 0.568 | 0.566 | 0.565 | | |
| L | 1.174 | 1.184 | | 1.177 | 1.177 | 1.177 | 1.177 | | |
| M | 1.365 | 1.375 | | 1.372 | 1.372 | 1.372 | 1.372 | | |
| N | 2.495 | 2.505 | | 2.501 | 2.500 | 2.501 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | 0.125 | 0.128 | 0.127 | 0.123 | | |
| Q | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| R | 0.240 | 0.260 | | 0.249 | 0.248 | 0.242 | 0.248 | | |
| S | 0.115 | 0.135 | | 0.129 | 0.127 | 0.126 | 0.124 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.221 | 3.221 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.245 | 0.244 | 0.237 | 0.244 | | |
| W | 0.115 | 0.135 | | 0.128 | 0.127 | 0.130 | 0.131 | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.760 | 0.760 | 0.760 | 0.760 | | |
| Z | 0.352 | 0.372 | | 0.362 | 0.362 | 0.362 | 0.362 | | |
| AA | 0.470 | 0.530 | | 0.502 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.628 | 0.624 | 0.628 | 0.628 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.250 | 0.245 | 0.242 | 0.245 | | |
| AE | 1.500 | 1.520 | | 1.513 | 1.512 | 1.513 | 1.513 | | |
| AF | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.266 | 0.265 | | |
| AH | 0.240 | 0.260 | | 0.250 | 0.245 | 0.246 | 0.250 | | |
| AI | 2.000 | 2.020 | | 2.002 | 2.003 | 2.003 | 2.002 | | |
| AJ | 0.023 | 0.043 | | 0.030 | 0.030 | 0.030 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | | | | |
|--------------|----------|----------|-------------|----------|
| Measured by: | J.S. | / En | Audited by: | ED |
| Date: | 06/03/07 | 06/03/07 | Date: | 06/03/07 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

